Work Order ID 112023

Tuesday, January 28, 2014 1:40:44 PM

112023

Item ID: D4805-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: End Fitting

Start Date: 1/28/2014 **Start Qty:** 6.00 *6*

Required Date: 2/14/2014 **Req'd Qty:** 6.00 *6*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MF **Date:** 14-1-28 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4805 Revision Nbr: Rev A									
100		0.00							
100						MF	14/1/30		
Outsource5	**Memo**	0.00							
Outsource process - Machining	ISSUE P/O: MF POSSIBLE SUPPLIER:ATG C OF C IS REQUIRED								
110	QC6- Inspect dimensions to drawing	0.00				6			
110						~~6~~			
QC	**Memo**	0.00							
Quality Control		DAS 27 9-89 M/3/12							
150		0.00							
150	PURCHASING								
Purchasing	**Memo**	0.00							
Purchasing	Issue P/O: _____ LPI Per ASTM 1417 LEVEL 2 Certificate of conformaty is required	DAS 27 9-89							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4805-3 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: End Fitting
Start Date: 1/28/2014 **Start Qty:** 6.00 *6* **Cust Item ID:**
Required Date: 2/14/2014 **Req'd Qty:** 6.00 *6* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Receive & Inspect for Damage & Mat'l Certs	0.00							
160						lex	5	14-3-12.	
Packaging	**Memo**	0.00							
Packaging	Ensure certificate of conformity is attached								
	5+123					14/3/13	6		DAS 32 9-89
190	QC21- Final Inspection - Work Order Release	0.00							
190						MCJ	14-03-13		
QC	**Memo**	0.00							
Quality Control									

MCJ 14-03-13

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

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General

☐ Bend
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☐ Burrs
☐ Contamination
☐ Countersink
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☐ Finish
☐ Fit/Function
☐ Folio/Program
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☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
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☐ Outside Dimensions
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☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

Tuesday, January 28, 2014 1:40:43 PM

Work Order ID: 112023

Parent Item: D4805-3

Parent Item Name: End Fitting

Start Date: 1/28/2014 **Required Date:** 2/14/2014

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP REV:A NEW ISSUE JLM 14-01-28 VERIFIED BY:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4805-3P End Fitting		Purchased	No				Each	0.0000		6	6	14-3-12	SP
M174PH-H900R1.375 17-4 SS H900 ROUND BAR 1.375		Purchased	No				f	90.0000		6	6	14/01/30	

Location	Loc Qty	Loc Code
MAT031	90	
111123	12	
121280	27	
m126952	51	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

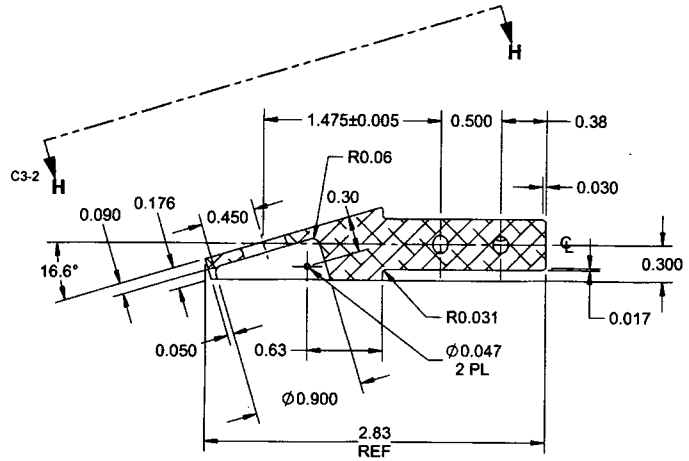
FAULT CATEGORY

Landing Gear

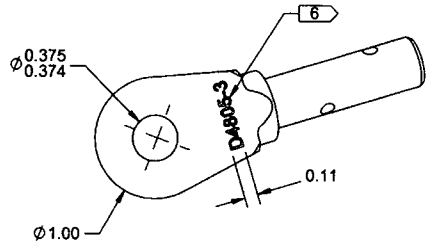
☐ Bending
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☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

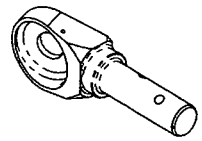
☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

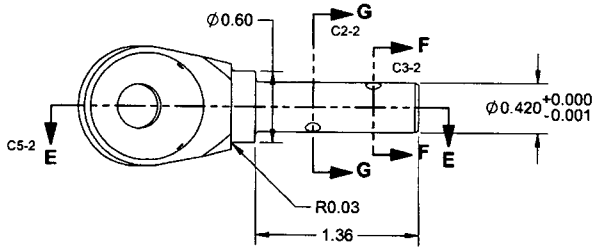


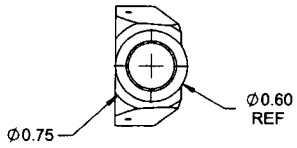
SECTION E-E B7-2

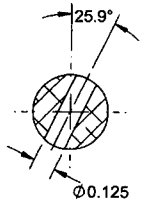


AUXILIARY VIEW H-H D7-2

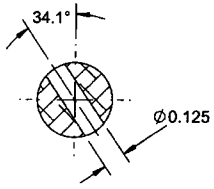








SECTION F-F B5-2



SECTION G-G B6-2

D4805-3 END FITTING

MF 14-1-28 #112023

2014-01-0

NOTES:
1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.11 HIGH LETTERS TO A MAX. DEPTH OF 0.010
7) WEIGHT: 0.13 lbs
8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED			
DESIGN	RF	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO. D4805	REV. A
MFG. APPR.	JLM		SHEET 2 OF 3
APPROVED	HS	TITLE END FITTING	SCALE NTS
DE APPR.	DS		
DATE	13.12.16		

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
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☐ Turning Sequence
☐ Wave/Twist in Tube

General

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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 907542 Date: 12-Mar-14

To

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577 Fax: 613 632-1053

Ship To

Michael Gregoire
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577 Fax: 613 632-1053

Terms	Ship Via

Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
6 ea	Part: D4805-3P END FITTING Job: 15716	PO: PO22838	Rev: A Line: 13
4 ea	Part: D4805-5P END FITTING Job: 15717	PO: PO22838	Rev: A Line: 14
3 ea	Part: D4806-1P CLEVIS Job: 15709	PO: PO22838	Rev: A Line: 6
6 ea	Part: D4808-1P ROD END Job: 15710	PO: PO22838	Rev: A Line: 7
7 ea	Part: D4869-1P END FITTING, EYE Job: 15711	PO: PO22838	Rev: A Line: 8
3 ea	Part: D4869-3P END FITTING, EYE Job: 15712	PO: PO22838	Rev: A Line: 9

DATE : 12/03/2014

CERTIFIED SIGNATURE:

RECEIVER SIGNATURE : _____

SP 14-3-12.

CERTIFICATE OF CONFORMANCE

A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT ARE IN CONFORMANCE WITH THE REQUIREMENTS, SPECIFICATIONS, AND DRAWINGS REFERENCED IN THE ABOVE PURCHASE ORDER.

First Article Inspection Report

ATG INDUSTRIES INC.

731 Industrielle St
Rockland, Ontario K4K 1T2
Ph: 613 446-4544

Customer:	Dart Aerospace	Date:	March 12th, 2014	462
Part Number:	D4805-3P	Revision:	A	
PO Number:	PO22838	Qty:	6	FAI No.

Item	Dimension	Measurement Inspected by: Rene Tougas, Q.C.	Remarks
1	1.475±.005	1.473	Section E-E
2	R.06	R.061	
3	.30	.299	
4	.500	.500	
5	.38	.378	
6	.030	.030	
7	.300	.301	
8	.017	.017	
9	R.031	R.031	
10	Ø.047	Ø.046	2 Places
11	2.83	2.837	
12	Ø.900	Ø.896	
13	.63	.628	
14	.050	.053	
15	16.6º	16.5º	
16	.090	.089	
17	.176	.172	
18	.450	.448	
19	Ø.375/.374	Ø.3748	Auxiliary View H-H
20	Note 6	X	
21	.11	.145	
22	Ø1.00	Ø1.003	
23	Ø.60	Ø.599	
24	Ø.420+.000/-.001	Ø4199	
25	1.36	1.361	
26	R.03	R.031	
27	Ø.60 REF	Ø599	
28	Ø.75	Ø.750	
29	25.9º	25.8º	Section F-F
30	Ø.125	Ø.125	

COPY

First Article Inspection Report

ATG INDUSTRIES INC.

731 Industrielle St
Rockland, Ontario K4K 1T2
Ph: 613 446-4544

Customer:	Dart Aerospace	Date:	March 12th, 2014	462
Part Number:	D4805-3P	Revision:	A	
PO Number:	PO22838	Qty:	6	FAI No.

Item	Dimension	Measurement Inspected by: Rene Tougas, Q.C.	Remarks
31	34.1º	34.2º	Section G-G
32	Ø.125	Ø.125	
33	Material:	17-4SS H900 1.375" RD BAR	Supplied by Customer
34	Treatment	Liquid Penetrant	PO#:20140098

COPY

skyservice **Work Order Traveler**
Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO20177	**Customer:** Cash Sale	**Dept:** NDT YUL	**Reference:** 20140098
Descr:	**PN:**	**S/N:**	**Qty:** 1
Make:	**Model:**	**Reg:**	**A/C S/N:**
TSN: 0	**CSN:** 0	**TSO:** 0	

Task: UNSCHEDULED | **Sequence:** 1

Work Required:

CARRY OUT NDT ON 33 PARTS AS PER PO: 20140098

Action Taken:	Date:	Initial/Stamp:
LPI C/O ASTM E-1417M-13 NO CRACK FOUND PEN.(ZL-37 , B#10A070), CLEAN(SKC-S,B#09F21K),DEV.(SKD-S2,B#09L04K) EMU.(ZR-10B,B#10A074).	MAR 10 2014	DOT - APP 20 53-89

Description	*Location*	*P/N*	*Qty*	*Batch*	*S/N Off*	*S/N On*

COPY

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	**ACA/SCA Stamp**	Date:
Name: RAFIK MELIKIAN	DOT - APP 20 53-89	MAR 10 2014

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO22838

Purchase Order Date 1/30/2014
PO Print Date 1/30/2014

Order From : VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name		**Buyer**	Michael Gregoire
Vendor Phone	613-446-4544	**Customer POID**	
		Customer Tax #	10127-2607
Ship To Contact		**Terms**	Net 30
Ship To Phone		**Currency**	CAD
Ship Via:	VENDOR'S TRUCK	**FOB**	FCA – (Free Carrier)
Ship Acct:			

11	D4871-3P	End Fitting	3/7/2014 Yes 3/7/2014	3.00 Each		$145.00	$435.00

Manufacture as per drawing D4871 rev.A
Made from 17-4SS H900 Round Bar 1.500"
B112019

Line Total: **$435.00**

12	D4805-1P	End Fitting	3/7/2014 Yes 3/7/2014	4.00 ✓ Each		$145.00	$580.00

Manufacture as per drawing D4805 rev.A
Made from 17-4SS H900 Round Bar 1.375"
B112022

SP 14-3-12

Line Total: **$580.00**

13	D4805-3P	End Fitting	3/7/2014 Yes 3/7/2014	6.00 ✓ Each		$145.00	$870.00

Manufacture as per drawing D4805 rev.A
Made from 17-4SS H900 Round Bar 1.375"
B112023

SP 14-3-12

PO Instructions: Procurement Quality Clauses
A004 FAA-PMA /TSO
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A016 PERSONNEL QUALIFICATION
A024 PROCESS CERTIFICATIONS
A025 CERTIFICATE OF CONFORMANCE
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM